

Date: Thursday, 14/08/2008 11:50:50 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP WELDMENT		
Job Number	: 41245			Part Number	: D3562041		
Estimate Number	: 12576			Drawing Number	: D3562 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 14/08/2008	S.O. No.	:	Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 21/08/2008		Qty: 2 Um: Each
Previous Run	: 41038						
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 06-11-09 JLM						
	Est rev B ECN 987 07.10.09 EC verified by: DD						
	Est Rev:C ECN1048 07-12-18 DD verified by:ec						
	Est Rev:D 08-07-28 add chemical conversion coat DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Step Extrusion	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>39316</u>			
Check Material for any Dents or Defects <i>SAD 08/08/14 (n)</i>			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding <i>08/08/14 (2)</i>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP <i>08.08.14 (2)</i>			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>FL 08/08/15 (2)</i>			

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14/08/28 2

6.0 D3560041 Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

ARM WELDMENT

Batch: 335295 = 1 340299 = 1

14/08/18 2

7.0 D3560043 Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

ARM WELDMENT

Batch: 335297

14/08/18 2

8.0 MS20600AD4W5 Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 64.0000 Each(s)

Blind Rivet

batch: 106431

14/08/12 2

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill.Rivet holes as per dwg D3562. SP

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnobond *****

A/R Magnabond 6398 Batch: m16695

SAN 08/08/28 2

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/28 2

W/O:

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3562041

Job Number:



Seq. #:	Machine Or Operation:	Description :
11.0	D2734	Step End Plate
		<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2734 End Cap 839179</p> <p>11/08-08-28</p>
12.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		<p>Comment: LARGE FABRICATION RESOURCE 1 1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/R Aluminum Rod 01108031</p> <p>11/08-08-28</p>
		<p>2-Grind end cap welds flush as per Dwg D3562</p> <p>08/10/29 11/08-08-28</p>
13.0	QC9	VISUAL WELDING INSPECTION
		<p>Comment: VISUAL WELDING INSPECTION</p> <p>PD 08-08-29</p>
14.0	QC5	INSPECT WORK TO CURRENT STEP
		<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p>S 08-08-29 X2</p>
15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		<p>Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1</p> <p>11/08-08-28 X2</p>
16.0	POWDER COATING	POWDER COATING <p>11/10/08 523</p>
		<p>Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3</p> <p>START TIME: 11:30AM OVEN TEMPERATURE: 326°F FINISH TIME: 12:00PM</p> <p>11/08-08-29 X2</p>

W/O:		WORK ORDER CHANGES					
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W/O:

WORK ORDER CHANGES

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Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M108496

jl

08-08-29

(xp)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Soe/09/02 (x2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

40853

RR

8/9/2

(2x)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/02 (ff)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



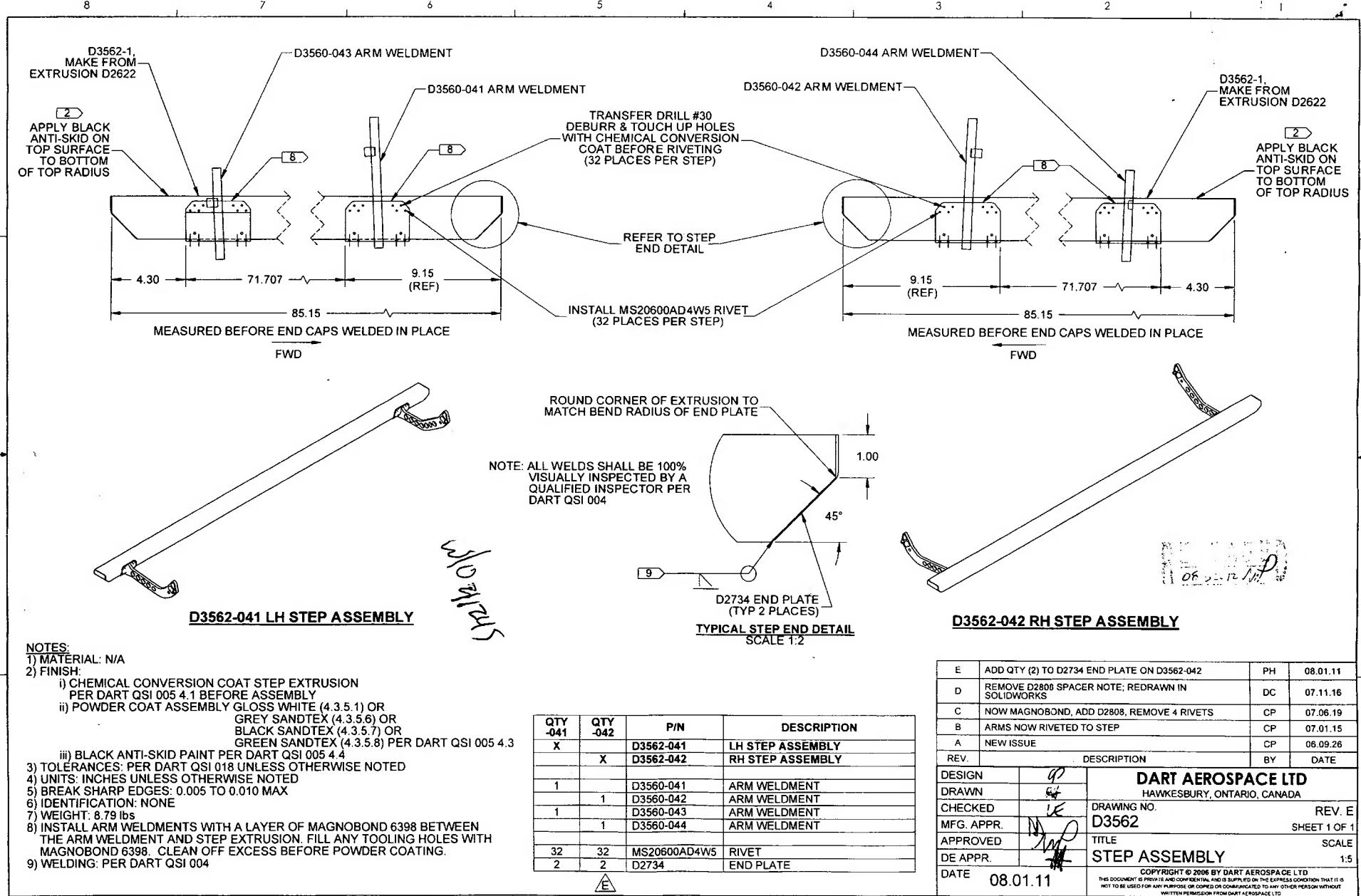
MF 08-09-02

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E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2800 SPACER NOTE; REDRAWN IN	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	9P	DART AEROSPACE LTD	
DRAWN	64	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.	M	D3562	SHEET 1 OF 1
APPROVED	M	TITLE	SCALE
DE APPR.	M	STEP ASSEMBLY	1:5
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS COMMUNICATED TO THE OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	